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D2616-1
Job Sheet 184373



Part No: D2616-1

Job Qty: 19 ea

Part Name: Mounting Lug, EC120 Step



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/9/18

Job Tracking No:

Created By: Jason Leroux

Due Date: 10/12/18

Description:

Type: Stock

Note: DWG D2616-1 REV:E IPP REV:D (REPROGRAMMED FOR HAAS 5) 18.08.09 RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	19 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	19 pcs	10/12/18	10/12/18	0.00	0.01	Bandsaw1		
110	CNC Vertical Machining	19 pcs	10/12/18	10/12/18	0.00	10.85	HAAS 5 Axis	DAS	
130	QC	19 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-1	52	
140	HandFinish	19 pcs	10/12/18	10/12/18	0.00	0.66	HandFinish1	9-89	
150	Powdercoat	19 pcs	10/12/18	10/12/18	0.00	0.27	Powdercoat3		
160	QC	19 pcs	10/12/18	10/12/18	0.00	0.00	QC3		
170	Small Fab	19 pcs	10/12/18	10/12/18	0.00	1.46	Small Fab-2		
180	QC	19 pcs	10/12/18	10/12/18	0.00	0.00	QC5		
190	Packaging	19 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-1		
200	QC21-SA	19 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks at 2.25"

Descriptions: 110 - 1-Machine as per folio FB477 & DWG D2616. 2- Deburr.

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Note:Mask large hole START TIME: 8:15 OVEN

TEMPERATURE: 320° FINISH TIME: 8:45

160 - QC3- Inspect Part Finish

170 - 1-Coat bearing in light oil 2-Press Bearing in D2616-1 3-Stake as per Dwg D2616 using DT8019 4- Touch up paint if required

180 - QC5- Inspect part completeness to step on W/O

190 - Identify as per dwg & Stock Location:

200 - QC21- Final Inspection - Work Order Release

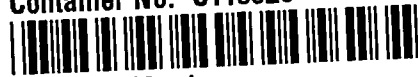
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2611	Bearing	19 Ea (1 ea)	90-Start up Operation	5107622
M6061T6B2.500X01.250	6061-T6 Bar 2.50 X 1.25	3.5625 ft (.1875 ea)	90-Start up Operation	5116817

5116819



Container No: S116820



Part: D2616-1

Job No: 184373

Serial No/Batch: S116820

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/09/18

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2611	19	79	0
	M6061T6B2.500X01.250	4	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Mounting Lug	17.000Degrees ± 0.500	17.500 16.500		
2	Fwd Mounting Lug	2.000inches ± 0.010	2.010 1.990		
3	Fwd Mounting Lug	0.622inches ± 0.010	0.632 0.612		
4	Fwd Mounting Lug	0.511inches ± 0.010	0.521 0.501		
5	Fwd Mounting Lug	0.313inches ± 0.010	0.323 0.303		
6	Fwd Mounting Lug	1.000inches ± 0.010	1.010 0.990		
7	Fwd Mounting Lug	1.125inches ± 0.010	1.135 1.115		
8	Fwd Mounting Lug	0.250inches ± 0.010	0.260 0.240		
9	Fwd Mounting Lug	1.250inches ± 0.010	1.260 1.240		
10	Fwd Mounting Lug	0.375inches ± 0.010	0.385 0.365		
11	Fwd Mounting Lug	0.625inches ± 0.010	0.635 0.615		
12	Fwd Mounting Lug	1.259inches ± 0.010	1.269 1.249		
13	Fwd Mounting Lug	0.625inches ± 0.010	0.635 0.615		
14	Fwd Mounting Lug	0.250inches ± 0.010	0.260 0.240		
15	Fwd Mounting Lug	0.063inches ± 0.010	0.073 0.053		
16	Fwd Mounting Lug	0.257inches + 0.006 - 0.001	0.263 0.256		
17	Fwd Mounting Lug	0.8120inches + 0.0000 - 0.0005	0.8120 0.8115		

Plex 10/9/18 8:17 AM dart.leroux.jason